



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D2579

Job Sheet 171737



Part No: D2579

Part Name: Crossbolt Spacer



Part Weight: 0 lbs

Job Created: 2/8/18

Due Date: 2/12/18

Type: SOLD

Note: DWG REV E IPP E 02.06.17 Now turned on Cobra NG IPP F 07.07.06 rev E dwg EC

Ship Via:

Job Qty: 50 ea

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50-Ea		2/12/18	0.00	0.00	Start Up Machining		FR 18-2-8
100	Hardinge	50 pcs		2/12/18	0.00	0.00	Hardinge		FR
110	QC	50 pcs		2/12/18	0.00	0.00	QC2		FR
120	QC	50 pcs		2/12/18	0.00	0.00	QC8		FR 18/02/02
125	Skidtubes	50 pcs		2/12/18	0.00	0.00	Skidtubes		FR
130	Packaging	50 pcs		2/12/18	0.00	0.00	Packaging3		FR
140	QC21-SA	50 Ea		2/12/18	0.00	0.00	QC21		FR 18-2-8

Part Op 100 - Machine as per Folio FA245

Descriptions: 125 - 1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

DAS
21
3:00

FEB 08 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	17.9150 ft (.3583 ea)	100-Hardinge	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge	M6061T6T0.500W.058	18	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	4.070inches $\pm$ 0.030	4.100 4.040	4.060	
2	Crossbolt Spacer	0.058inches $\pm$ 0.010	0.068 0.048	.056	

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐		Skid-tub	
NCR No. _____		Scrap ☐		Machin	
Date: _____		Use-as-is ☐		Thermoformir	
Step #: _____		Suspected Unapproved ☐		Large Fa	
Description Work Order Deviation		QTY Eff			
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Ci ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damag ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Inco ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Inc ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐		
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐				
OTHER : _____					

PART NO: D2579

Original Serial #: S040524

Revision:

Operation:

Change No:

Start up Operation 02/08/18

Job No: 171737

Crossbolt Spacer

S040524

DART AEROSPACE

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DART AEROSPACE LTD	Work Order:	171737
Description: Crossbolt Spacer	Part Number:	D2578
Inspection Dwg: D2578 Rev: E		Page 1 of 1

INSPECTION CHECKLIST

[illegible]

Measured by: <i>FR</i>	Audited by: <i>amf</i>	Preliminary Approval:
Date: 18-2-8	Date: 18/02/08	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	